

Work Order ID 82678

82678

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April-04-12 1:56:59 PM

Item ID: D350-636-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Toe Step, LH/RH

Start Date: 04/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/04 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3487

Rev A

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

110

0.00

110

Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg *** D3487-1***

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

6061-T6 .100

Handwritten notes and signatures:
 (20) *[Signature]*
 Hg for MLJ 12-4-23
 (20)
 (20) *[Signature]* Jan-12-4-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									<i>12-4-10</i>
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									<i>conf</i> <i>(720)</i>
150	NC BRAKE	0.00							
150									
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3487								<i>20</i> <i>SB</i> <i>12/04/12</i>

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

8-12-11-18

*count
x20*

Quality Control

170 Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

(20) 7/6 12-4-19 BL

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

ATTN: PAINT GLOSSY BLACK
START TIME: *7:40* OVEN TEMPERATURE:

FINISH TIME:

3200F

8-10

20X PTD 12/04/19 M-R

m121134

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/18/18	180	permanent change				12/18/18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Wing Walk as per dwg QSI005 4.4 Batch 120802 0.00

190

HandFinish

Memo

0.00

Hand Finishing

20 φ PL 12-4-19 Ⓟ

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

20x φ Jul 12/04/12

210

Packaging

0.00

210

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-636-101

Location:

PPP Rev: A

20x φ RP
12-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

12/4/25

MF
12-04-25

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 82678

82678

Parent Item: D350-636-101

D350-636-101

Parent Item Name: Toe Step, LH/RH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	93.4000	0.7942	16.72			

M6061T6S 100

**

6061-T6 .100 Sheet

Location	Loc Qty	Loc Code
MAT021	93.4	
102201	1	
118072	12.4	
118523	80	

118523

20

12-4-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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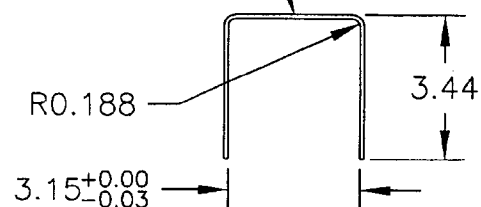
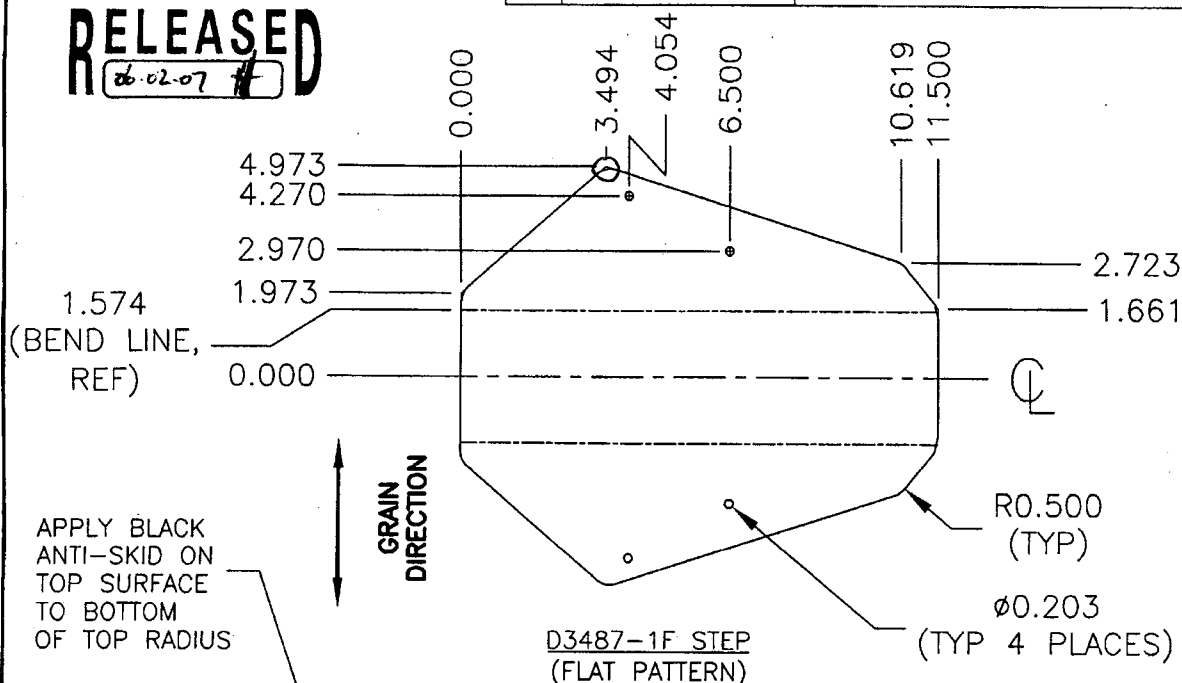
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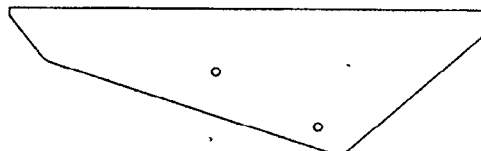


DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
06-02-07 #



D3487-1 STEP
(BENDING DETAIL)



12/04/04
NO. 82678 MW
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3487-1 STEP

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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